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(11) **EP 1 072 712 A1**

(12) **EUROPEAN PATENT APPLICATION**

(43) Date of publication:
31.01.2001 Bulletin 2001/05

(51) Int. Cl.⁷: **D04H 11/00**, B32B 7/12,
B32B 5/16, B32B 27/12,
B05D 1/16, B60J 10/00

(21) Application number: 00202626.8

(22) Date of filing: 21.07.2000

(84) Designated Contracting States:
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU
MC NL PT SE
Designated Extension States:
AL LT LV MK RO SI

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(30) Priority: 26.07.1999 IT MI991649

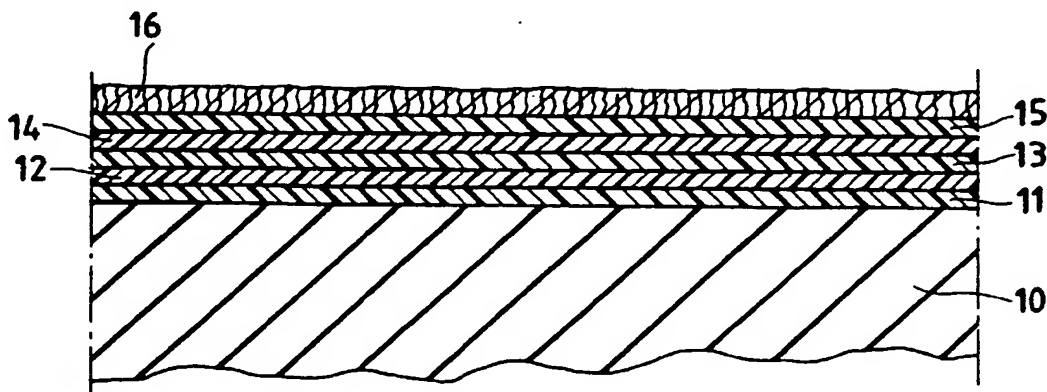
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(54) **Improved flocked material and method for its preparation**

(57) The present invention regards a flocked material characterized in that it comprises one or more layers made of flexible thermoplastic material chosen from among polymers and copolymers of olefins, as such or in a mixture with other polymers or elastomers, there

being applied or formed *in situ*, on the external surface of the one of the said layers that carries the flocking material, a layer of polyurethane adhesive for adhesion of the flocking material.



plum flocked

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Description

[0001] As is known, using the so-called flocking technique, suitable substrates are coated with fibres referred to as "flock", which in general have a thickness of the order of a few millimetres, so as to render these substrates velvety.

[0002] The flocked substrates, according to the present invention are window-scraper sealing strips for glass run channel profiles in motor vehicles, which profiles consist of a rigid part that supports a flocked flexible part so as to facilitate sliding of the windows and prevent vibration of the window inside the door and the consequent noise during use of the vehicle.

[0003] As is known, flocking of a substrate is generally obtained by means of a flocking machine. The main types of flocked substrates consist, for example, of rubber-based materials to be inserted in a rigid substrate made of metal or of plastic material having particular characteristics of rigidity.

[0004] There exist, moreover, flocked substrates made of thermoplastic rubber, which can be made by co-extrusion of a rigid substrate made of thermoplastic material and of a flexible portion made of thermoplastic rubber.

[0005] Flocking of this type of co-extruded combination is made by introducing the material into the flocking machine after co-extrusion.

[0006] In order to get the flock to adhere, adhesive is spread over the aforesaid co-extruded substrate, this requiring prior application of anchoring primers, or of solvents that present problems of handling because they are harmful and at times even toxic.

[0007] It would therefore be advisable to avoid the use of the said solvents and chemical additives.

[0008] In addition, a flocking system of the above kind requires in-line plants, which consequently require a lot of space, as well as environmental depuration systems, given that the substances necessary for the process are harmful.

[0009] It is evident that the above characteristics involve problems of being anti-economic.

[0010] Flocks made of PVC are moreover known. These can be made by co-extruding a PVC having characteristics of rigidity as a substrate and a PVC having characteristics of softness as the flexible part.

[0011] Also in this case, flocking takes place after co-extrusion, as was described previously for flocking of substrates made of thermoplastic rubber.

[0012] In this case, adhesives that do not present such high levels of toxicity may be required, but there remains even so the problem of the use of very costly in-line equipment.

[0013] For PVC substrates, a more economic solution is, however, possible as an alternative to in-line flocking by forming a pre-flocked ribbon obtained from a PVC film which has already been flocked and which is subsequently bonded, at output from the extruder, to the

rigid PVC strip when the latter is still hot, either by directly passing it through the extrusion head or in the sizer positioned after the extrusion head.

[0014] A purpose of the present invention is to achieve flocking of a substrate such as that made of thermoplastic rubber whereby it is not necessary to use, as has been done up to now in the known art, harmful, or even worse, toxic solvents and costly in-line plants, which necessarily involve also environmental depuration systems for treating the above-mentioned solvents.

[0015] In other words, the purpose of the invention is basically to achieve flocking of the sort referred to above for the PVC substrate obtained by bonding a pre-flocked ribbon to substrates that are far more advantageous than PVC itself, i.e., those consisting of thermoplastic rubbers.

[0016] In the case of window-scraper sealing strips for glass run channel profiles for motor vehicles, the car manufacturers require a minimum critical value of adhesion of the flock to the rubber support in the profile, which is usually not lower than 15 N/cm.

[0017] Since rubber, especially thermoplastic rubber, and a flocking material such as polyester scarcely adhere one to another, the basic purpose of the present invention is to find an ideal interface between the two of them which can fulfil the above requirement.

[0018] Furthermore, such flocked material should also provide a highly flexible sealing strip in the form of a ribbon to be wound in rolls, to be supplied to the car manufacturers as a pre-flocked ribbon which they will be able to join to the rubber support in order to provide the channel profile.

[0019] For the purposes of the present invention, such material should also perform a very tight sealing action towards the window of the vehicle in every condition.

[0020] According to the present invention, it is also wanted to avoid phenomena of deformation, such as elongation or contraction, of the flocked ribbon during its bonding in extrusion with the rigid substrate.

[0021] To achieve the above purposes and other advantages that will appear more clearly in what follows, the present invention proposes a flocked material to be used as a window-scraper sealing strip for glass run channel profiles in motor vehicles, characterized in that it comprises one or more layers made of flexible thermoplastic material chosen from among polymers and copolymers of olefins either as such or mixed with other polymers or elastomers, on the external surface of the one of the said layers that carries the flocking material, there being applied a layer of polyurethane adhesive material for adhesion of the flocking material.

[0022] According to the present invention, by "polyurethane adhesive" is meant the polymer as such or the product of polymeric reaction of any suitable precursor. The latter will thus be any compound that is able to form, by reaction with isocyanate, a plurality of urethane groups or even biuret. The said precursor will therefore

contain amine, hydroxyl or hydrogen reactive groups. According to a first embodiment, the polyurethane thus formed is crosslinked.

[0023] In an alternative embodiment, the said precursor is a non-crosslinked urethane pre-polymer which will undergo crosslinking *in situ* during forming of the flocked material.

[0024] In a further embodiment of the present invention, the polyurethane adhesive may also be non-crosslinked and water-based.

[0025] The layers that make up the flocked material referred to above are made of flexible thermoplastic material chosen preferably from among polypropylene, polyethylene, ethylene-propylene copolymer, as such or mixed with natural or synthetic rubbers, or polyurethane or polyester resins.

[0026] In a preferred embodiment, between the external surface of the layer that carries the flocking material and the polyurethane adhesive there is interposed a primer, for example polyethylene imine.

[0027] According to the invention, the flocked single-layer or multilayer film thus formed may be transformed into a ribbon as such, or else be made to adhere to a thermoplastic-rubber substrate, for instance, directly inside an extruder, or else at output from the extruder itself, or in a sizer after extrusion.

[0028] As an alternative to the said thermoplastic rubber, it is possible to use a natural rubber, or else a synthetic elastomer, or EPDM.

[0029] Another purpose of the present invention is a method for forming the said material.

[0030] According to a preferred embodiment of the said method, the process starts from a film obtained from one or more layers of polyolefin or of an ethylene or propylene copolymer, or else from mixtures of such polymers, either together or with other polymers or with natural or synthetic rubbers, or polyurethane or polyester.

[0031] The above-mentioned stratified material may be subjected to a corona discharge treatment so as to obtain on at least one of the surfaces, or even on both surfaces of the single layer or of the multilayer, a surface tension preferably of at least 38 dyne/cm².

[0032] On one or both of the faces of the single-layer or multilayer film thus obtained, a primer can then be laid.

[0033] On one of the surfaces thus treated a suitable amount of a mixture which will produce the said polyurethane adhesive for anchoring the flocking material is spread using a doctor blade or some other suitable means. The mixture may therefore be, for instance, an appropriate mixture of crosslinkable pre-polymer and an isocyanic crosslinking agent.

[0034] The next step in the process is the operation of flocking, which is carried out using a flock of polyester or polyamide or other suitable fibre, dyed or pigmented or raw, having a pre-chosen length and nature.

[0035] In order to provide a better description of the

characteristics and advantages of the invention, in what follows some examples of practical implementation are given, which, however, are not intended as limiting the scope of the invention.

EXAMPLE 1

[0036] A single-layer film having a thickness of between 60 micron and 150 micron, consisting of an ethylene-propylene copolymer, or polyethylene homopolymer or polypropylene homopolymer, or mixtures of the two, undergoes corona discharge treatment and is subsequently treated with an aqueous solution of polyethylene imine, e.g., Polymin P produced by Basf, with or without the addition of a melaminic crosslinking agent. From 0.5 grams to 15 grams of polyethylene imine are laid out per square metre.

[0037] After this treatment, the film is spread out using a doctor blade or roto-screen in a flocking machine equipped with a slat conveyor, with a crosslinkable or non-crosslinkable water-based polyurethane adhesive, such as

*MOR-AD EPW 12/64/T25	100 parts
*MORAD 7000/T5	2-5 parts
*VITADERM ASZ	0-5 parts
AMMONIA	0-5 parts

* Trademarks of Morton International S.p.A.

[0038] From 150 to 350 grams are laid per square metre. The surface thus spread is flocked with a polyester flock - dtex 3.3 dyed in paste black or another colour; length of fibre from 0.75 to 2 mm - up to complete coverage of the surface.

[0039] After being dried in an oven and after start of crosslinking, the entire product is treated with a primer on the reverse side to favour gripping to the thermoplastic rubbers; or else, if the chosen film has suitable characteristics, it is left without primer to be transformed into a ribbon subsequently.

EXAMPLE 2

[0040] A film made up of a number of co-extruded layers or layers bonded together, which has a thickness of between 60 micron and 150 micron and consists of an ethylene-propylene copolymer or a polyethylene homopolymer or a polypropylene homopolymer, or of mixtures of the two, and of films of polyurethane, polyester, polyamide or other suitable polymers, undergoes a corona discharge treatment and subsequently treated with an aqueous solution of polyethylene imine, such as

Polymin P produced by Basf, with or without the addition of a melaminic crosslinking agent. From 0.5 to 15 grams of polyethylene imine per square metre are laid. After this treatment, the film is spread out using a doctor blade or rotoscreen in a flocking machine equipped with a slat conveyor, with a polyurethane adhesive or with mixtures of crosslinkable or non-crosslinkable water-based polyurethane adhesive, such as

*RU6135	80 parts
*RU9018	20 parts
*XR2500	3 parts
*RM4456	as required for thickening
AMMONIA	1-5 parts

* Trademarks of Stahl Italia S.p.A.

[0041] From 100 to 450 grams are laid per square metre. The surface thus spread is flocked with a polyester flock - dtex 3 dyed in paste black or another colour; length of fibre 0.70 mm - up to complete coverage of the surface.

[0042] After being dried in an oven and after start of crosslinking, the entire product is treated with a primer on the reverse side to favour gripping to the thermoplastic rubbers; or else, if the chosen film has suitable characteristics, it is left without primer to be transformed into a ribbon subsequently.

EXAMPLE 3

[0043] The procedure is the same as the one described in the foregoing Example 2, this time applying as polyurethane adhesive a two-component polyurethane terminating in hydroxyl groups, which is made to react in the presence of an isocyanic reactive group-based crosslinking agent. According to the present example, the two-component polyurethane is the product that goes under the commercial name "Tyforce AS 141" modified (100 parts), whilst the cross-linking agent (from 5 to 10 parts) is a trimethylol propane/tolylene diisocyanate adduct.

[0044] According to the present example, the two-component polyurethane is dissolved in an aprotic polar solvent, such as, preferably, DMF.

[0045] After the above adhesive has been applied and after flocking has been carried out, the flocked material is put into an oven at a temperature of between 80 and 120 °C for between 2 and 5 minutes.

[0046] The crosslinking reaction takes place after evaporation of the DMF solvent in the oven of the flocking plant. Crosslinking is then completed at room temperature.

EXAMPLE 4

[0047] The procedure is again the same as that for the foregoing Example 2, applying as polyurethane adhesive the following:

Crosslinkable pre-polymer	70-80 parts
Crosslinking agent	20-30 parts
Accelerating agent	0.5-3 parts

[0048] After application of the adhesive and after flocking, the material is put into an oven at a temperature of between 80 and 120 °C for between 2 and 5 minutes. In the present example, the pre-polymer is a polyurethane having a sufficiently low molecular weight as to enable its being spread in a flocking plant. This pre-polymer terminates in blocked isocyanic groups. Practically the entire crosslinking process takes place in the drying oven, where the blocking agent of the isocyanate is released by the effect of heat.

EXAMPLE 5

[0049] The procedure is again the same as that for the foregoing Example 2, applying as polyurethane adhesive the following mixture:

Polyol	80-100 parts
Isocyanic crosslinking agent	20-40 parts

[0050] After application of the adhesive and after flocking, the material is put into an oven at a temperature of between 80 and 120 °C for between 2 and 5 minutes. The mixture of the ingredients of the adhesive is prepared *in situ* with a suitable mixing apparatus, which may be heated, whilst the reaction of polyurethane formation and crosslinking of the polyurethane takes place immediately after flocking.

EXAMPLE 6

[0051] The procedure is again the same as that for the foregoing Example 2, using as adhesive a polyurethane terminating in isocyanic groups that is able to crosslink in the drying oven of the flocking plant by effect of the water contained in a controlled-humidity atmosphere.

[0052] In this case, the adhesive is used in amounts of between 100 and 120 parts together with a viscosity modifier in amounts of between 2 and 5 parts. After application of the adhesive and after flocking, the mate-

rial is put into an oven at a temperature of between 80 and 120 °C for between 2 and 5 minutes.

[0053] Crosslinking takes place in the drying oven of the flocking plant in conditions of controlled humidity and subsequently at room temperature.

[0054] In all the above examples, the adhesion of the flocking material to the rubber support in the final profile is > 15 N/cm.

[0055] Just to provide an example, a flocked material according to the invention is shown in the figure of the attached drawing.

[0056] This drawing refers in particular to a flocked material to be used to make a window-scraper for the door of a motor vehicle.

[0057] The finished flocked material shown in the figure consists of a substrate made of thermoplastic rubber 10 on which a primer 11 is laid for adhesion of the multilayer made of flexible thermoplastic material to the thermoplastic rubber.

[0058] The above multilayer is made up of a first layer of polypropylene 12, on which a layer of ethylene-propylene polymer 13 is laid.

[0059] On the top surface of the latter is laid a primer 14 to favour application of a layer of polyurethane adhesive 15, which enables anchoring of the flocking material 16.

[0060] From the above descriptions and examples it may be understood how the flocked material according to the present invention enables the purposes and advantages initially stated to be effectively achieved.

[0061] In particular, in the case of a crosslinked polyurethane adhesive, the finished flocked material is characterized by high dimensional stability even at a high temperature, as well as resistance to solvents.

[0062] The above properties prevent the danger of deformation of the ribbon and risks of failure.

Claims

1. Flocked material characterized in that it comprises one or more layers made of flexible thermoplastic material chosen from among polymers and copolymers of olefins, as such or in a mixture with other polymers or elastomers, there being applied or formed, on the external surface of the one of the said layers that carries the flocking material, a layer of polyurethane adhesive for adhesion of the flocking material.
2. Flocked window-scraper sealing strip for glass run channel profiles for vehicles, characterized in that it comprises one or more layers made of flexible thermoplastic material chosen from among polymers and copolymers of olefins, as such or in a mixture with other polymers or elastomers, there being applied or formed, on the external surface of the one of the said layers that carries the flocking material, a layer of polyurethane adhesive for adhesion of the flocking material.
3. Flocked window-scraper sealing strip for glass run channel profiles according to Claim 2, characterized in that the said polyurethane adhesive is a crosslinked polyurethane.
4. Flocked window-scraper sealing strip for glass run channel profiles according to Claim 3, characterized in that the said polyurethane is crosslinking by reaction with isocyanate of precursor compounds containing hydroxyl, or amine, or hydrogen reactive groups.
5. Flocked window-scraper sealing strip for glass run channel profiles according to Claim 3, characterized in that the said crosslinked polyurethane is obtained by crosslinking *in situ* a urethane pre-polymer.
6. Flocked window-scraper sealing strip for glass run channel profiles according to Claim 3, characterized in that the said polyurethane adhesive is crosslinked in an aqueous base.
7. Flocked window-scraper sealing strip for glass run channel profiles according to Claim 2, characterized in that the said polyurethane adhesive is non-crosslinked and water-based.
8. Flocked window-scraper sealing strip for glass run channel profiles according to Claim 2, characterized in that it comprises a primer interposed between the said surface and the said layer and the said polyurethane adhesive.
9. Flocked window-scraper sealing strip for glass run channel profiles according to Claim 2, characterized in that it is joined to a basic substrate made of a less flexible material, such as rubber.
10. Flocked window-scraper sealing strip for glass run channel profiles according to Claim 9, characterized in that a primer is interposed between the said basic substrate and the substrate of the said flexible layers facing the basic substrate.
11. Flocked window-scraper sealing strip for glass run channel profiles according to Claim 2, characterized in that it comprises one or more layers of flexible thermoplastic material chosen from among the following: polypropylene, polyethylene, and ethylene-propylene copolymer, as such or as mixtures thereof.
12. Flocked window-scraper sealing strip for glass run channel profiles according to claim 8, characterized in that the said primer is a polyethylene imine.

13. Method for forming a flocked material comprising one or more layers of thermoplastic material to be made in the form of a ribbon which is to be used as such or to be made to adhere to a basic substrate of a material such as rubber or thermoplastic rubber to form a flocked stratified material, characterized in that the said thermoplastic material is chosen from among the polymers and copolymers of olefins, as such or in a mixture with other polymers and elastomers, there being applied or formed *in situ*, on the external surface of the one of the said layers that is to carry the flocking material, a layer of polyurethane adhesive, the said layer being then subjected to flocking.
14. Method according to Claim 13, characterized in that before the said adhesive is applied to the said external surface of the said layer, a primer is applied to the said surface.
15. Method according to Claim 13, characterized in that before the said adhesive is applied to the said external surface of the said layer, the latter is subject to a corona discharge treatment to obtain on the said surface or on both surfaces thereof a pre-defined minimum surface tension.
16. Method for forming the said flocked material according to Claim 1, characterized in that after the said flocking operation, a primer is applied to the non-flocked surface of the said layer made of thermoplastic material in order to prepare for adhesion of the said layer to the said basic substrate.
17. Method according to Claim 13, characterized in that bonding of the said basic substrate and of the said single-layer or multilayer flocked material is performed during the extrusion stage or at output from extrusion.
18. Glass run channel profile including a flocked window-scraper sealing strip according to claim 2.

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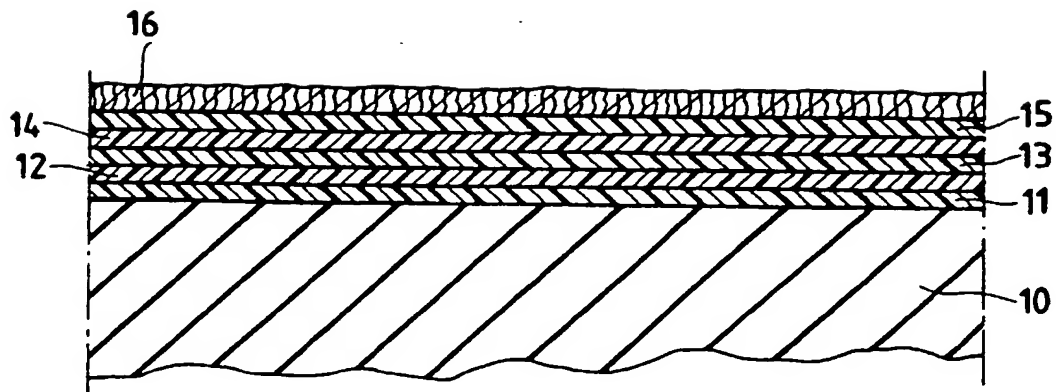
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EUROPEAN SEARCH REPORT

Application Number
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The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 20 October 2000	Examiner Pamies Olle, S
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ----- & : member of the same patent family, corresponding document</p>			

EPO FORM 1503 03/82 (P04C01)



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EUROPEAN SEARCH REPORT

Application Number
EP 00 20 2626

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